

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005666**Date Inspected:** 21-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Dan Hernandez was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 14 OBG Assembly

Segment 7EW

Shielded Metal Arc Welding (SMAW) of weld joint SEG041A-004 located on BP93A to SP155A. Welder is identified as 066258. ZPMC QC is identified as Wu Bin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 7DW

Shielded Metal Arc Welding (SMAW) of weld joint SEG039A-031 located on BP92A to SP154A. Welder is identified as 067572. ZPMC QC is identified as Wu Bin. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 6AE

Submerged Arc Welding (SAW) of weld joint SEG028B-031 located on BP113A to SP361A. Welder is identified as 048296. ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

### Segment 2AE

Flux Cored Arc Welding (FCAW) of weld joint DP612-001-247, 252, 257, 262, 267, 272, 277 located on Floor Beam Diaphragm X98F to DP612 and DP597-001-,092, 087, 084, 079, 076, 071, 068, 063, AND 060 located on Floor Beam Diaphragm X98C to DP597. Welder is identified as 044801. ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

### Bay 13 OBG Assembly

#### Segment 1BE

Flux Cored Arc Welding (FCAW) of weld joint SSD45-PP12.5-136, 135 located on FB53B to LD29A. Welder is identified as 044774.

FCAW of weld joint SSD45A-PP12.5-135, 136 located on FB54B to LD30A. Welder is identified as 051356.

FCAW of weld joint SEG006C-001, 002 located on FB68A to LD30A. Welder is identified as 0555491.

FCAW of weld joint SEG006B-001, 002 located on FB88A to LD29A. Welder is identified as 044774.

FCAW of weld joint SSD47A-PP11-129 located on FB68A to FB80B. Welder is identified as 055564.

ZPMC QC is identified as Huang Shuai. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

---

|                      |                  |                             |
|----------------------|------------------|-----------------------------|
| <b>Inspected By:</b> | Hernandez,Dan    | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Clifford,William | QA Reviewer                 |

---